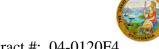
## **DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES Office of Structural Materials Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133 (707) 649-5453 (707) 649-5493



Contract #: 04-0120F4

Cty: SF/ALA Rte: 80 PM: 13.2/13.9

File #: 1.28

## WELDING INSPECTION REPORT

Resident Engineer: Casey, William **Report No:** WIR-026855 Address: 333 Burma Road **Date Inspected:** 09-Dec-2011

City: Oakland, CA 94607

**OSM Arrival Time:** 700 **Project Name:** SAS Superstructure **OSM Departure Time:** 1530 **Prime Contractor:** American Bridge/Fluor Enterprises, a JV

Contractor: American Bridge/Fluor Enterprises, a JV **Location:** Job Site

**CWI Name:** Salvador Merino **CWI Present:** Yes No **Inspected CWI report:** Yes N/A **Rod Oven in Use:** Yes No No N/A N/A **Electrode to specification:** Yes No **Weld Procedures Followed:** Yes No N/A **Qualified Welders:** Yes No N/A **Verified Joint Fit-up:** Yes No N/A N/A Yes No N/A **Approved Drawings:** Yes No **Approved WPS: Delayed / Cancelled:** Yes No N/A

34-0006 **Bridge No: Component: SAS OBG** 

### **Summary of Items Observed:**

Caltrans Office of Structural Material (OSM) Quality Assurance Inspector (QAI) Joselito Lizardo was present at the Self Anchored Suspension (SAS) job site as requested to perform observations on the welding of components for the San Francisco Oakland Bay Bridge (SFOBB) Project.

At OBG 14E-PP127.2-E5 vent hole infill plate to top deck plate inside, ABF welder Erick Sparks was observed continuing to perform 4G Shielded Metal Arc Welding (SMAW) welding fill pass to cover pass on the infill plate to top deck plate butt joint. The welder was noted using 1/8" diameter E7018H4R implementing Welding Procedure Specification (WPS) ABF-WPS-D15-1110A Rev.1 for the Seismic Performance Critical Member (SPCM) butt joint. During welding, ABF QC Salvador Merino was noted monitoring the welder's welding parameters with measured working current of 130 amperes on the 1/8" diameter E7018H4R electrode. The welder was noted preheating the plates to more than 150°F using propylene gas torch prior welding. During the shift, cover pass welding was completed on the bottom side of the butt joint.

At the request of Quality Control Field Supervisor, Bonifacio Daquinag, QA has randomly verified the QC VT/MT of the Complete Joint Penetration (CJP) welding of six (6) vent hole infill plate and four (4) lifting lug infill plate to top deck plate butt joints. The QA verification was performed to verify that the welding and the VT/MT inspection performed by the QC inspector meet the requirements of the contract documents. At the conclusion of the QA verification it appeared that the weld and the QC inspection complied with the contract documents.

1. OBG 14W-PP126.2-W3.2 outside - QA VTMT verified

# WELDING INSPECTION REPORT

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- 2. OBG 14W-PP126.7-W3.2 outside QA VTMT verified
- 3. OBG 14W-PP126.2-W3.7 outside QA VTMT verified
- 4. OBG 14W-PP125.7-W3.7 outside QA VTMT verified
- 5. OBG 14W-PP126.2-W2.4 outside QA VTMT verified
- 6. OBG 14W-PP125.2-W4.2 outside QA VTMT verified
- 7. OBG 14E-PP125-E4-#1 lifting lug hole infill plate to top deck plate outside QA VTMT verified
- 8. OBG 14E-PP125-E4-#2 lifting lug hole infill plate to top deck plate outside QA VTMT verified
- 9. OBG 14E-PP125-E4-#3 lifting lug hole infill plate to top deck plate outside QA VTMT verified
- 10. OBG 14E-PP125-E4-#4 lifting lug hole infill plate to top deck plate outside QA VTMT verified

At OBG 14E-PP125-E4-#1 to 4 lifting lug hole infill plate to top deck plate outside, the lifting lug holes adjacent base metal (approximately 6" to 8") were tested using Magnetic Particle Testing (MT) in addition to the same test that was performed to the same holes for the purpose of information only in view of the found linear indication on one (1) of the lifting lug holes.

## **Summary of Conversations:**

No significant conversation ocurred today.

#### **Comments**

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact SMR Nina Choy 510-385-5910, who represents the Office of Structural Materials for your project.

<b>Inspected By:</b>	Lizardo, Joselito	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer